

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012468**Date Inspected:** 04-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Wuzhi Chang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

**OBG TRIAL ASSEMBLY****LIFT:** 6 West line (Panel Point (PP) #40~47)

This QA Inspector Randomly performed joint Inspection along with Caltrans QA Manoj Prabhune for the Panels flatness at Lift-6 West between PP#40~47. The following two locations are not comply with the contract document.

During random flatness inspection this Caltrans Quality Assurance Inspector (QA) observed a following Issues:

- The Deformation was measured to be approximately 24 mm in 2250 mm Maximum template size.
- The Segment and Panel Point no is 6AW-PP#40 Facing West at Crossbeam (CB) Side.
- The Deformation was measured to be approximately 26 mm in 2250 mm Maximum template size.
- The Segment and Panel Point no is 6CW-PP#44 Facing West at CB Side.

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

This QA generated a report on this date for the above issue and submitted to the Task Leader for further action. The attached photographs provide additional detail.

LIFT: 6 West line (PP #37~47)

This QA Inspector performed dimension check for the longitudinal diaphragm weld length from the cope hole to the weld termination point for OBG Lift: 6 West from PP#40 to PP#47 at W3 Location along with Caltrans QA Inspector Mr. Manoj Prabhune. The measured readings were fed in spread sheet, generated the report and submitted to the Task Leader for further action.

LIFT: 5 West line (PP#29~36)

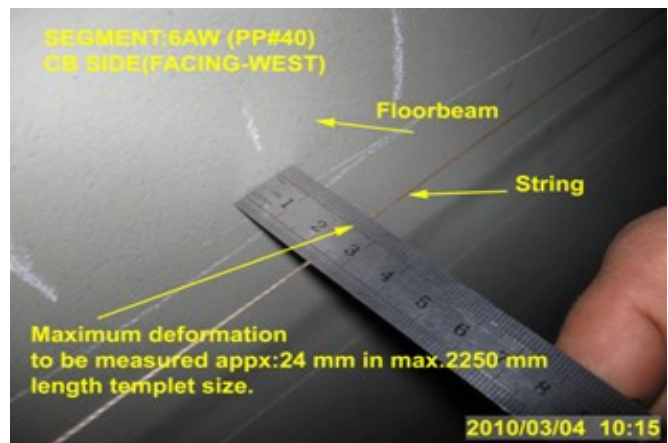
This QA Inspector performed dimension check for the longitudinal diaphragm weld length from the cope hole to the weld termination point for OBG Lift: 5 West from PP#29 to PP#36 at W3 Location along with Caltrans QA Inspector Mr. Manoj Prabhune. The measured readings were fed in spread sheet, generated the report and submitted to the Task Leader for further action.

This QA Inspector Randomly observed the following work in progress:

SEGMENT: 6CW

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint SSD25-PP045-117. Welder is identified as 054467. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F) Repair-1. The repair welding was been performed against the Welding Repair Report (WRR) No: B-WR10796 and ZPMC Ultrasonic Testing (UT) Report No: B787-UT-11462.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

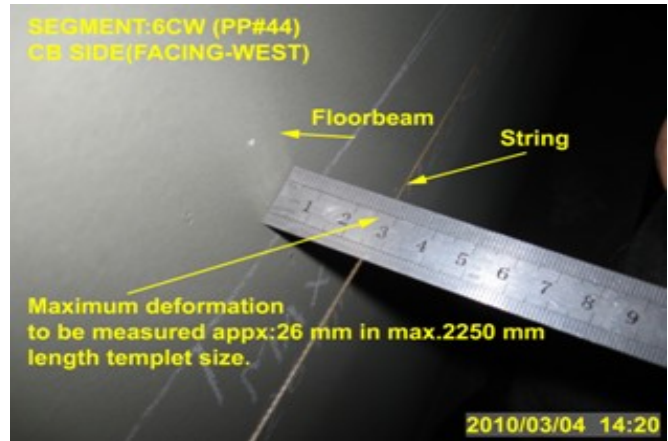
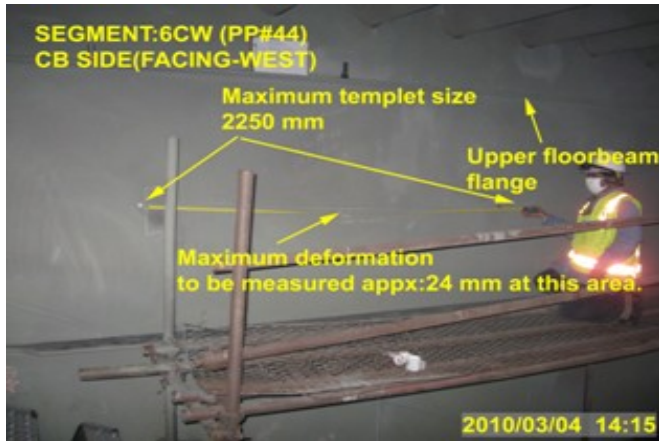


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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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## Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhu,Surendra	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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